

DART AEROSPACE LTD		Work Order:	22126
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	20
		Page 1 of 2	

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler <i>DWG NOT REQUIRED 04.07.05</i>	<i>[Signature]</i>	05.01.04	20																				
2	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-1 Batch: <u>M16241</u>	<i>[Signature]</i>	05/01/04	20																				
3	MV	Cut blanks: 2.00" x 1.00" x 2.550" long Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick (M6061T6B1.000x02.000) Identify for D3278-2 Batch: <u>M16241</u>	<i>[Signature]</i>	05/01/04	20																				
4	MV	Machine D3278-1 as per Folio FA405 and Dwg D3278 Identify as D3278-1	<i>[Signature]</i>	05/01/05	20																				
5	QC2	Inspect parts as they come off the CNC machine	<i>[Signature]</i>	05/01/05	20																				
6	MV	Deburr and Tumble	<i>[Signature]</i>	05/01/05	20																				
7	QC8	Second check	<i>[Signature]</i>	05/01/05	20																				
8	MV	Machine D3278-2 as per Folio FA405 and Dwg D3278 Identify as D3278-2	<i>[Signature]</i>	05/01/05	20																				
9	QC2	Inspect parts as they come off the CNC machine	<i>[Signature]</i>	05/01/05	20																				
10	MV	Deburr and Tumble	<i>[Signature]</i>	05/01/05	20																				
11	QC8	Second check	<i>[Signature]</i>	05/01/05	20																				
12	FP	Acid etch and Alodine as per QSI 005 4.1	<i>[Signature]</i>	05-01-06	20																				
13	QC5	Inspect work to Step 12	<i>[Signature]</i>	05 01 07	20																				
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	<i>[Signature]</i>	05 01 07	20																				
15	QC3	Inspect Powder Coat	<i>[Signature]</i>	05-01-07	20																				
16	GA	Rivet spacers with support as per Dwg D3278. (Note: D3278-1/-2 are on BOM as material from Steps 2-3) Pick: Packing Kit <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3278-1</td><td>Support</td><td>B22126</td></tr><tr><td>1</td><td>D3278-2</td><td>Support</td><td>B22126</td></tr><tr><td>1</td><td>D3278-3</td><td>Spacer</td><td>B21203</td></tr><tr><td>4</td><td>MS20426AD3-6</td><td>Rivet</td><td>M1563</td></tr></table>	Qty	Part Number	Description	Batch	1	D3278-1	Support	B22126	1	D3278-2	Support	B22126	1	D3278-3	Spacer	B21203	4	MS20426AD3-6	Rivet	M1563	<i>[Signature]</i>	05-01-07	20
Qty	Part Number	Description	Batch																						
1	D3278-1	Support	B22126																						
1	D3278-2	Support	B22126																						
1	D3278-3	Spacer	B21203																						
4	MS20426AD3-6	Rivet	M1563																						
17	QC5	Inspect work to Step 16	<i>[Signature]</i>	05-01-07	20																				

RELEASED

10/04-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
2020-03-03	2	Bad Rivet Try to fix		Scrap 1x 03-078-3 1x 03-078-2 1x 03-078-1	scf 05-078-1			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22126
Description: Support Assembly		Part Number:	D3278-041
Dwg: D3278 Rev. A		Qty:	20
		Page 2 of 2	

Step	Location	Procedure	By	Date	Qty																				
18	GA	Assemble support as per Dwg D3278 Pick: Packing Kit <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2230-1</td> <td>Clamp</td> <td>B21396</td> </tr> <tr> <td>2</td> <td>AN4-13A</td> <td>Bolt</td> <td>M15928</td> </tr> <tr> <td>4</td> <td>AN960JD416</td> <td>Washer</td> <td>M15331</td> </tr> <tr> <td>2</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M15030</td> </tr> </tbody> </table> Identify as D3278-041	Qty	Part Number	Description	Batch	2	D2230-1	Clamp	B21396	2	AN4-13A	Bolt	M15928	4	AN960JD416	Washer	M15331	2	MS21042L4	Nut (or -4)	M15030	ml	05-01-10	20
Qty	Part Number	Description	Batch																						
2	D2230-1	Clamp	B21396																						
2	AN4-13A	Bolt	M15928																						
4	AN960JD416	Washer	M15331																						
2	MS21042L4	Nut (or -4)	M15030																						
19	QC5	Inspect work to Step 18	18	05-01-10	20																				
20	ST	Identify and Stock	cy	05/01/10	20																				
21	AC	Cost / part <u>41.43</u>	Suc	05-01-11	20																				
22	DC	Close W/O <u>40.59</u> Inspect Level 21	dy	05.01.12	20																				

Rev	Date	Change	Revised By	Approved
A	04.04.19	New issue	KJ/JLM	<i>[Signature]</i> 04.04.22

RELEASED
[Signature] 04.04.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-01-10	18	Stack up tolerance issue between 2290-1 clamp and 3278-1/2 supports. clamp is tight between supports.	<i>AB</i>	- ok to assemble - Engineering to review clamps	<i>AB</i> 05-01-10	<i>AB</i> 05-01-10	<i>AB</i> 05-01-10	

Part No: D3278-041 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *SP* Date: 05/04/26

NOTE: Date & initial all entries

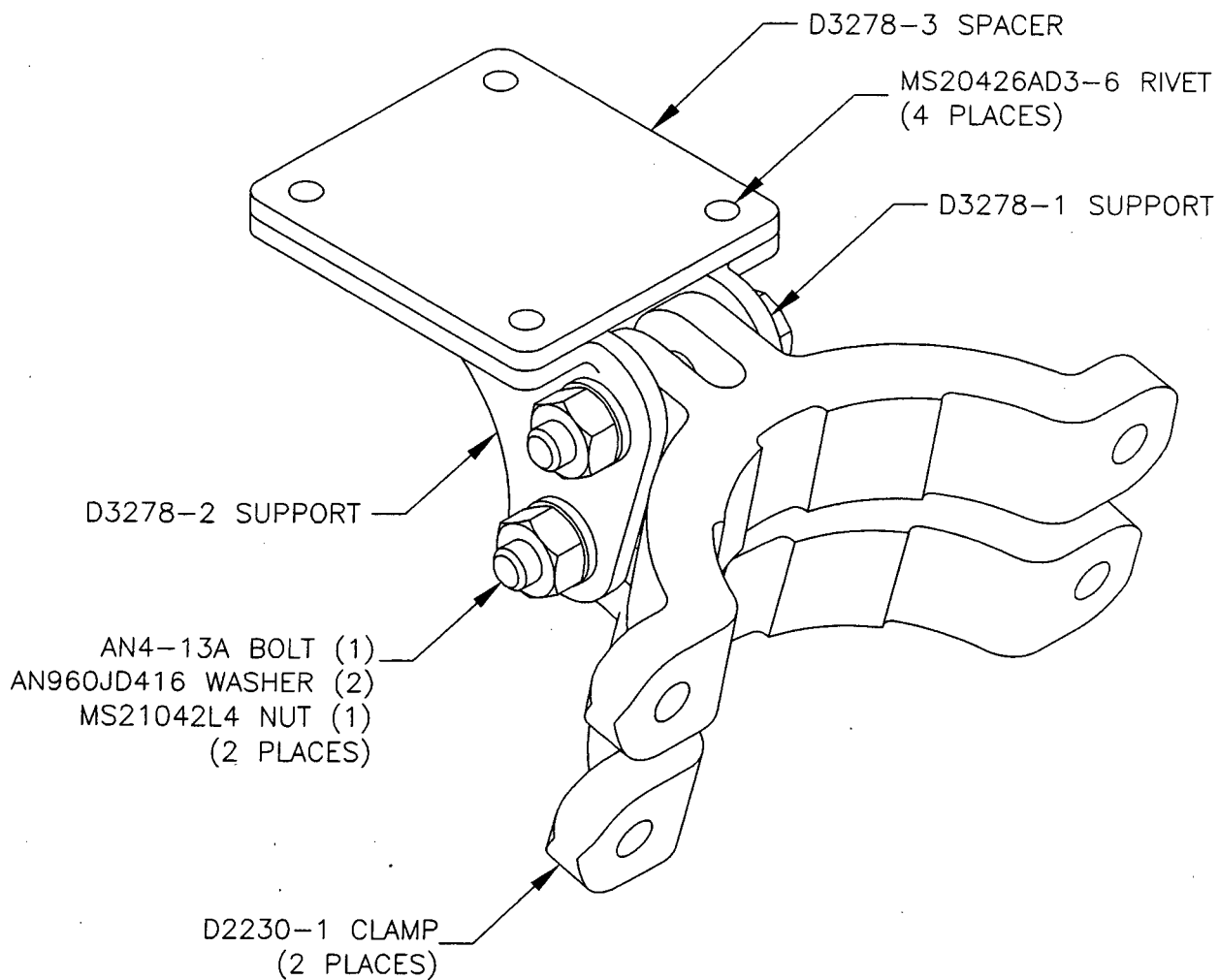
QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3278	REV. A SHEET 1 OF 3
DATE 04.03.03		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	

RELEASED
04.04.05 H

D3278-041 SUPPORT ASSEMBLY



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DART AEROSPACE LTD		Work Order: 22126
Description: Support Assembly		Part Number: D3278-041(-1)
Inspection Dwg: D3278 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.439	± 0.010	2.436	✓		vern	
Ø 0.098	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.098	✓		vern	
0.365	± 0.010	0.380	✓		vern	
0.615	± 0.010	0.620	✓		mic	
0.250	± 0.010	0.252	✓		vern	
1.480	± 0.010	1.478	✓		vern	
R. 0.125	± 0.010	0.125	✓		R.G	
0.125	± 0.010	0.122	✓		mic	
R. 0.400	± 0.010	0.400	✓		R.G	
1.980	± 0.010	1.984	✓		1-2" mic	
R. 0.13	± 0.030	0.130	✓		R.G	
Ø 0.257	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	0.257	✓		vern	
R. 0.375	± 0.010	0.375	✓		R.G	
Ø 0.075	± 0.010	0.075	✓		vern	
0.500	± 0.010	0.502	✓		vern	
1.720	± 0.010	1.725	✓		vern	
0.125	± 0.010	0.129	✓		mic	
R. 0.125	± 0.010	0.125	✓		R.G	

Measured by: <i>EP</i>	Audited by: <i>md</i>	Prototype Approval: <i>U/A</i>
Date: <i>05/01/06</i>	Date: <i>05/01/06</i>	Date: <i>U/A</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 22126
Description: Support Assembly		Part Number: D3278-041 (-2)
Inspection Dwg: D3278 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.439	± 0.010	2.439	✓		vern	
$\phi 0.098$	± 0.005 ± 0.002	0.098	✓		mic	
0.365	± 0.010	0.367	✓		mic	
0.615	± 0.010	0.620	✓		mic	
0.250	± 0.010	0.250	✓		vern	
1.480	± 0.010	1.478	✓		vern	
R. 0.125	± 0.010	0.125	✓		R.G.	
0.125	± 0.010	0.130	✓		mic	
R. 0.400	± 0.010	0.400	✓		R.G.	
1.980	± 0.010	1.984	✓		1-2" mic	
R. 0.13	± 0.030	0.13	✓		R.G.	
$\phi 0.257$	± 0.005 ± 0.000	0.257	✓		vern	
R. 0.375	± 0.010	0.375	✓		R.G.	
0.875	± 0.010	0.875	✓		vern	
0.500	± 0.010	0.500	✓		vern	
1.720	± 0.010	1.720	✓		vern	
0.125	± 0.010	0.130	✓		mic	
R. 0.125	± 0.010	0.125	✓		R.G.	

Measured by: <i>EN</i>
Date: 05/01/05

Audited by: <i>gml</i>
Date: 05/01/05

Prototype Approval: <i>N/A</i>
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 21, 2004
08:33 am

Work Order No : 0022126
Project Name : D3278-041
Project For : WK452
Work Order Type : Main
Main WO Number :
House Part Number : D3278-041
Description : Support Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 12-21-04
Est Finish Date : 12-21-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00